

Work Order ID 127113

December-08-14 10:38:54 AM

127113

Page 1

Item ID: D3121-25 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Delrin Cap
 Start Date: 09/12/2014 Start Qty: 100.00 ***100*** Cust Item ID:
 Required Date: 12/12/2014 Req'd Qty: 100.00 ***100*** Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3121	Rev E								

100 Hardinge CNC LATHE SMALL 0.00
100
 Hardinge Memo 0.00 100 36
 Hardinge CNC Lathe Small 1-Turn D3121-25 Cap as per Folio FA3872-Deburr 14.12.08

110 QC2- Inspect parts off machine FAI/FAIB 0.00
110
 QC Memo 0.00 100 36
 Quality Control 14.12.08

120 QC8- Inspect parts - second check 0.00
120
 QC Memo 0.00 100 37
 Quality Control 9-89 14.12.09

Work Order ID 127113

December-08-14 10:38:54 AM

127113

Page 2

Item ID: D3121-25

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Delrin Cap

Start Date: 09/12/2014 Start Qty: 100.00

100

Cust Item ID:

Required Date: 12/12/2014 Req'd Qty: 100.00

100

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location: 5108

0.00

130

Packaging

Memo

0.00

100

DEC 09 2014

DAS

06

9-09

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

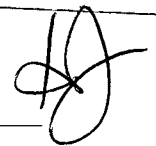
140

QC

Memo

0.00

Quality Control

14/12/10 ME
14-12-90

Picklist Print

December-08-14 10:38:53 AM

Page 1

Work Order ID: 127113

127113

Parent Item: D3121-25

D3121-25

Parent Item Name: Delrin Cap

Start Date: 09/12/2014

Required Date: 12/12/2014

Start Qty: 100.00

Required Qty: 100.00

Comments:

IPP Rev:A New Issue 06-05-10 JLM

IPP Rev:B ECN 1060 07-11-12 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MDELRINR1.2500

Purchased

No

100

f

15.6850

0.052

6

MDFI RINR1 2500

**

DELIN ROUND BAR 1.25" color: black

Location

Loc Qty

Loc Code

MAT039

15.685

m128113

15.685

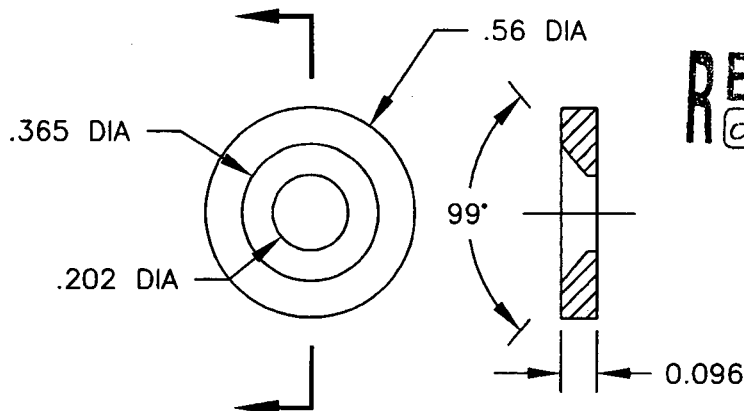
~~4.6~~

36 14.12.08

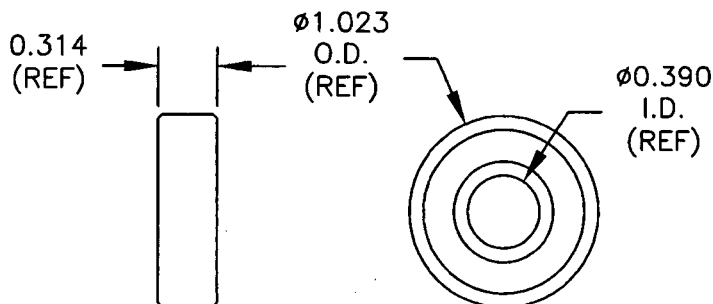
5.6

DART

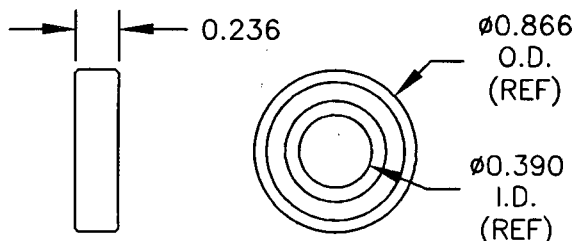
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

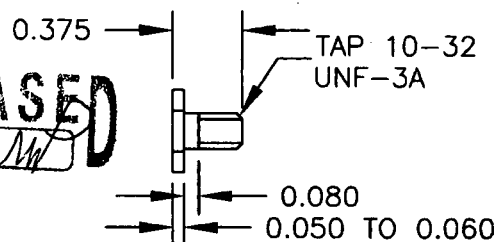
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

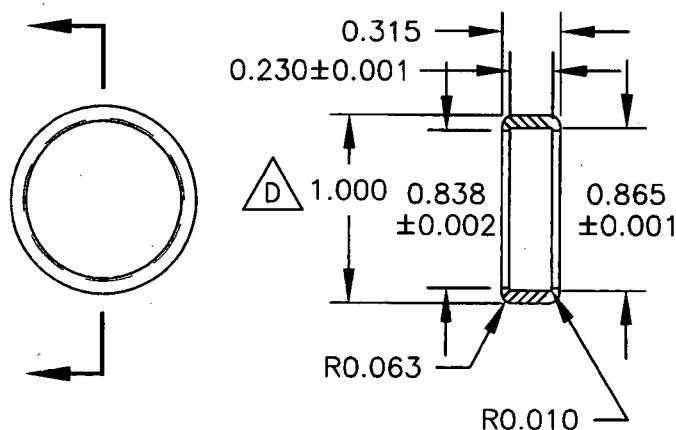
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

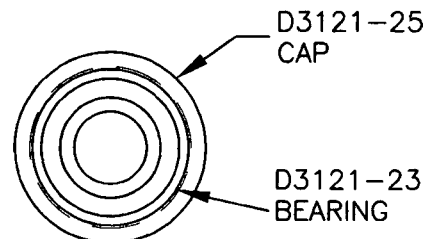
- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-2Z
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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